



Montana® Big Sky® Product Information Sheet

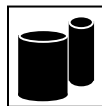
Technical Support (888) 276-7071

TDS_BS_PS3201-03-05

Direct to Metal Primer/Surfacer PS3201™ (White) PS3203™ (Gray) PS3205™ (Black)

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICAL SUPPORT.

COMPONENTS



PS3201™ White DTM Primer/Surfacer
PS3203™ Gray DTM Primer/Surfacer
PS3205™ Black DTM Primer/Surfacer
PA3200M™ DTM Activator Medium/ PA3200S™ DTM Activator Slow
TH0800 Series Urethane Grade Reducer

DESCRIPTION:

PS3201™/PS3203™/PS3205™ is a non-isocyanate, chromate-free, direct to metal primer that provides optimum adhesion with excellent corrosion protection on bare metals and OEM substrates. These primers are designed for use as a medium or high build primer-surfacer that easily sands by hand or machine, while offering superior color holdout and gloss retention for fast, high quality finishes.

SURFACE PREPARATION

- **Note:** Be sure to completely remove rust or oxidation prior to applying primer. Rust and oxidation can be removed by media blasting, grinding, or sanding. Properly Clean metal and painted surfaces with Wax & Grease Remover or Zero VOC Waterborne Surface Cleaner.
- **Steel:** Finish sand with 80 - P180 grit sandpaper.
- **Aluminum, Galvanized, Stainless Steel:** Sand with P320 grit sandpaper or scuff using a red scuff pad to remove light oxidation and abrade the surface.
- **SMC, Fiberglass:** Finish sand with P180 to P240 grit sandpaper.
- **Bare Rigid Plastic:** Use AP100™ Flexible Parts Cleaner and AP200™ Plastic Adhesion Promoter.
- **Repairs:** sand repair area and featheredge as needed, finish the featheredge with P320 grit sandpaper. Final sand the area surrounding the repair and featheredge using P400 or finer.
- **Existing finishes:** sand with P220 to P320 grit sandpaper to remove oxidation before priming.

✓ **Tech Tip:** Check for solubility by rubbing the E-coat with a rag and thinner or urethane reducer several times. If the E-coat dissolves with solvent, we recommend removing it prior to refinishing.

- In all cases re-clean repairs with appropriate surface cleaner to remove sanding residue before priming.

COMPATIBLE SUBSTRATES

- Properly cleaned steel, aluminum, galvanized steel, fiberglass and SMC.
- Thoroughly scuffed OEM E-coat and sanded cured paint.
- Cured, sanded body filler.
- Properly prepared plastic.

Note: Do Not use over lacquer primer or lacquer finishes.

MIX BY VOLUME



As a Normal Build Surfer Average per coat film build 1.5 mils approximately.

- 4 Part PS3201™/PS3203™/PS3205™
- 1 Part DTM Activator
- 1 Part TH0800 Series Urethane Reducer.

As a High Build Surfer Average per coat film build 2.0 mils approximately.

Note: Only two coats are suggested due to increased film builds, or extend dry times for a third coat.

- 4 Part PS3201™/PS3203™/PS3205™
- 1 Part DTM Activator
- ½ Part TH0870 Series Thinners

Note: We recommend using activators within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

TINTING

- DTM primers may be blended together to achieve various shades of the gray scale.
- No other tints or toners may be added. **Do not** mix with paint.
- See chart below for shading recommendations.

PS3201	PS3201 & PS3203 MIX 2:1	PS3201 & PS3203 MIX 1:2	PS3203	PS3203 & PS3205 MIX 2:1	PS3203 & PS3205 MIX 1:2	PS3205
Light Colors Very LT Colors Light Yellows Whites Sivers	Pastel Green Med. Yellow Light Tan Med. Silver Pastel Blue	Green Dark Silver Med. Light Tan Med. Light Red Med. Light Blue	Med. Red Med. Brown Med. Green Med. Blue Med. Gray	Dark Red Dark Brown Dark Blue Dark Green Med. Dark Gray	Dark Green Dark Blue Dark Brown Dark Red Dark Gray	Deep Dk Red Deep Dk Brown Deep Dk Green Deep Dk Blue Black

POT LIFE



- 2 hour at 75°F/23°C. **Note:** Warmer temperatures will shorten pot life.
- Clean equipment immediately after use.

EQUIPMENT SETUP



HVLP
High Efficiency

Fluid Tip

1.4 – 1.6 mm
1.4 – 1.6 mm

Air Pressure

8 - 10 PSI at the cap
27 - 32 (PSI) Inlet Pressure

APPLICATION AS A PRIMER



- Apply in single wet coats, allowing 5- 10-minutes flash at 75°F/23°C between coats.
- For normal build, apply 2-3 coats, depending on desired film build.
- For high build, we suggest 2 coats maximum. If three coats are applied, allow for overnight drying.
- Body filler may be applied 1 hour after a single coat of PS3201™/PS3203™/PS3205™ has been applied.
- Additional heat may be applied to speed curing and drying. Allow to cool before sanding.

Brushable / Rollable Option

- Mix according to directions. **Note:** The use of slower reducers will increase flow and leveling.
- Apply 1 even coat of PS3201™/PS3203™/PS3205™, making sure to cover the repair area completely into the featheredge.
- Before the 2nd coat is applied, allow a 10 minute flash between coats.
- Apply the 2nd coat within the previous coats outer edge.
- For best results, do not apply more than 3 coats.

DRY TIME TO SAND



Primer Option (Allow for proper flash time between coats during application)

- Air Dry: 45 minutes to 1 hour per coat at 75°F/23°C. Overnight for 3 coats using high build 4:1 mix.
- Bake: 20 minute flash followed with 140°F/60°C for 15 – 20 minutes.
- Infrared short wave: Allow to flash 20 minutes then 5 minute per coat air dry or low power heat), followed by a 5 minute per coat bake using full power @ 150°F/66°C.
- Final sand with P400 - P600 grit sandpaper and topcoat within 24 hours.

DRY TIME TO TOPCOAT

- After sanding should be topcoated within 4 – 6 hours @75°F/23°C

PLASTIC (RIGID) PARTS ONLY

- For bare plastic repair, use AP100™ Flexible Parts Cleaner and AP200™ Plastic Adhesion Promoter. **Refer to TDS_BS_AP100-200 for information and product use of AP100™ and AP200™.
- We suggest applying PS3201™/PS3203™/PS3205™ mixed at a 4:1:1 ratio.
- Apply only 1 – 2 coats of primer over the repair area. Avoid excessive film builds.

COMPATIBLE TOPCOATS

- System 10™ Acrylic Enamel Color
- System 20™ Synthetic Enamel Color
- System 28™ 2.8 VOC Polyurethane Color
- System 50™ SkyBase® Basecoat Color
- Metalux® International Basecoat Color
- Polyurethane Topcoats
- Acrylic Urethane Primer-Surfacers
- System 12™ Acrylic Enamel Color
- System 22™ Acrylic Urethane Color
- System 35™ 3.5 VOC Polyurethane Color
- PS3050 Series Urethane Sealers
- Acrylic Urethane Topcoats
- Acrylic Enamels

NOT RECOMMENDED FOR USE UNDER WATER BASED BASECOAT UNLESS SEALED WITH A COMPLIANT 2K URETHANE SEALER.

SPECIAL NOTES: Shop and surface temperatures should be maintained at or above 75°F/ 23°C for the first 24-hours of the cure cycle. Cooler temperatures may result in slower drying, curing and overall performance.

- Ensure proper metal conditioning/preparation procedures in early stages are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions are followed.
- Maintain accurate measuring during mixing.

Physical Data

	Mix 4:1:1/2	Mix 4:1:1
Dry to Sand @75°F/23°C	45 min. to 1 hour per coat	45 min. to 1 hour per coat
Film Thickness	2.0 ± .5 mils per coat	1.5 ± .4 mils per coat
Volume Solids	43%	39.5%
VOC Applied	4.13	4.39
Theoretical Coverage RTS	691 sq. ft. @ 1 mil dft	635 sq. ft. @ 1 mil dft
Flash Point	See SDS	See SDS

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY & HEALTH

Read and follow all technical product information, labels, and SDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

COMPANY INFORMATION

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